Pickup Box Outer Side Panel Replacement (Bond-On)

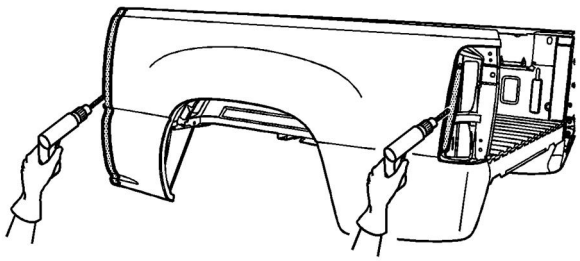
Removal Procedure

Warning: Refer to Approved Equipment for Collision Repair Warning.

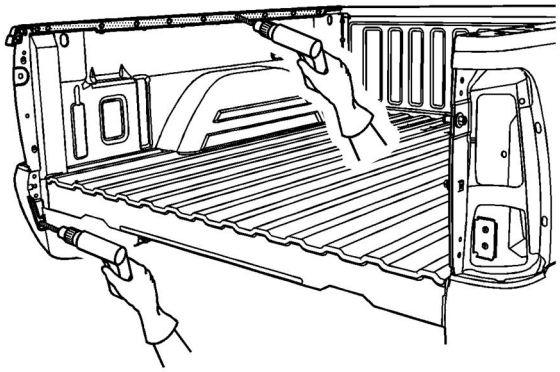
Note: This adhesive bonding procedure represents one manufacturer's installation application. Other manufacturers' procedures may vary, including MIG welding in some areas of the repair. Always follow the system manufacturer's instructions for application, handling, and curing.

Note: Before you begin the repair, refer to Metal Panel Bonding for proper adhesive preparations and general information.

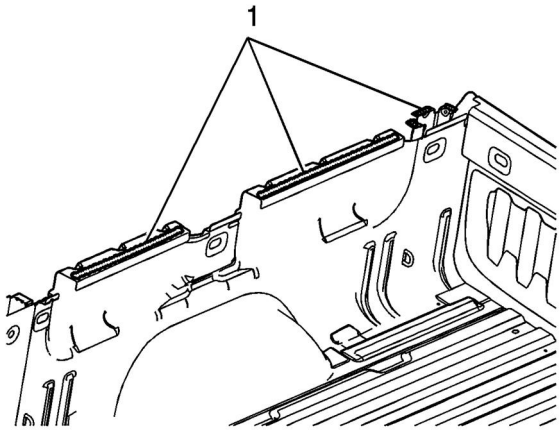
1. Remove the box assembly. Refer to Pickup Box Replacement.
2. Remove all related panels and components.
3. Repair as much or the damage as possible, according to factory specifications.
4. Note the location and remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.



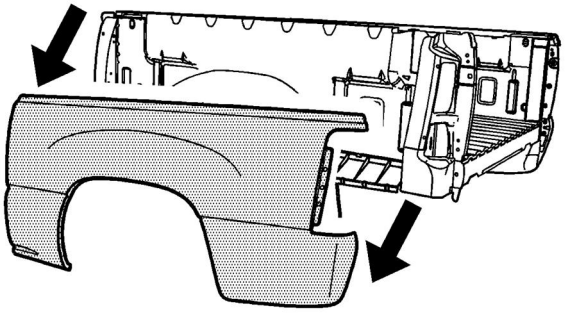
5. Locate and drill out the spot welds attaching the front panel, the wheelhouse, and the tail lamp pocket area.



6. Locate and drill out spot welds on the upper rail and the rear sill area.

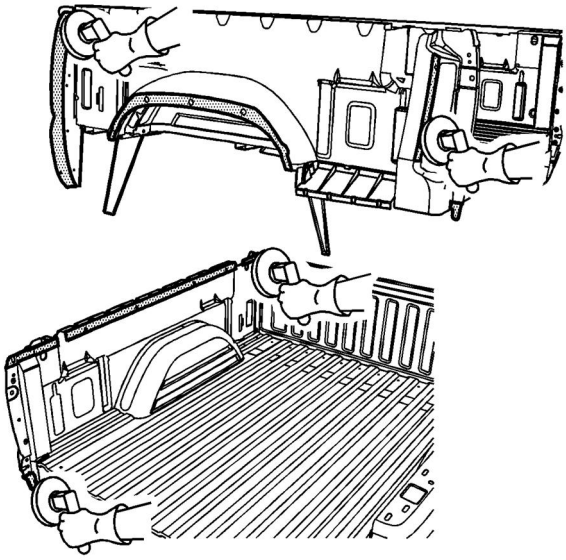


7. Structural adhesive is present between the upper inner panel (1) and the outer panel. If necessary, use a chisel to separate the outer panel from the inner panel.

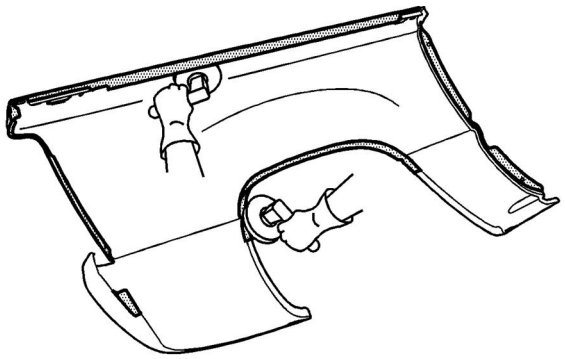


8. Remove the side panel.

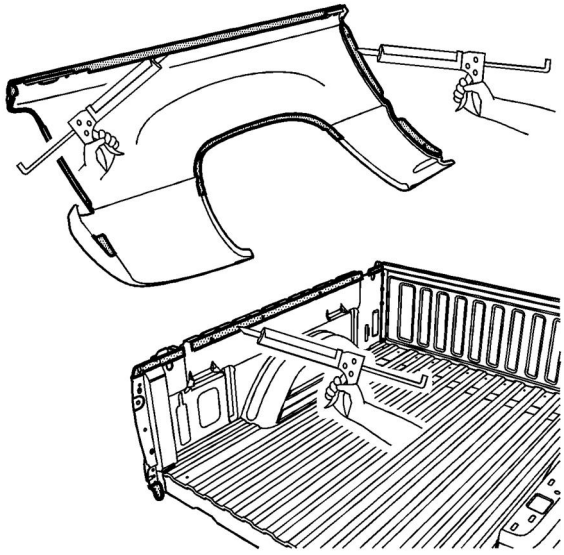
Installation Procedure



1. Grind the surface of the bed assembly mating flanges to bare steel. Do not damage the corners or thin the metal during the grinding process.

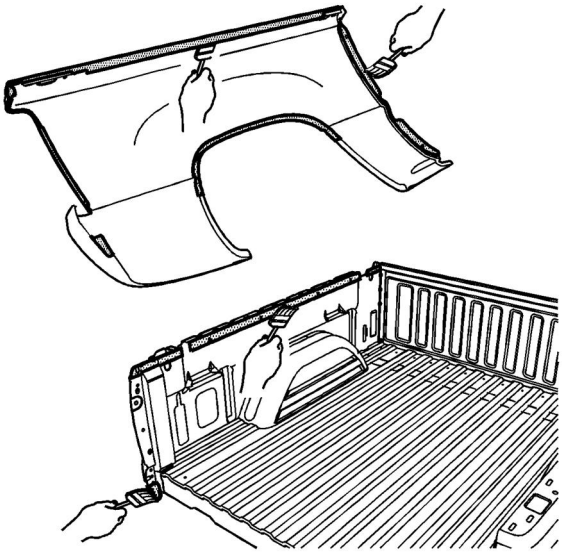


2. Grind the mating flanges of the service side panel to remove the E-coating. Do not damage the corners or thin the metal during the grinding operation.
3. Clean the mating surfaces.

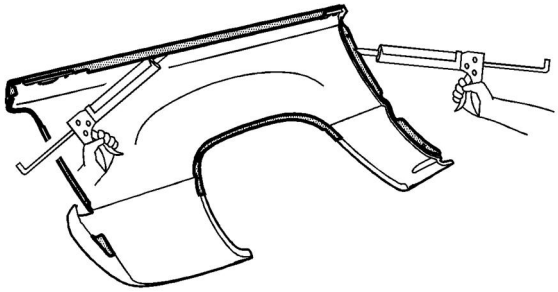


Note: Do not allow the adhesive to cure prior to installing the service side panel.

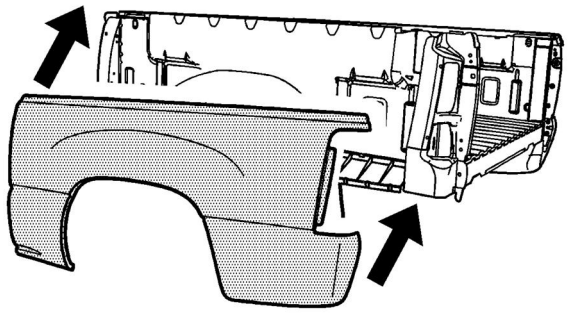
4. Apply a 3–6 mm (1/8–1/4 in) bead of metal panel bonding adhesive to both of the mating surfaces.



5. Using a small acid brush, spread a coat of adhesive to both of the mating surfaces. Cover all of the bare metal to ensure corrosion protection.

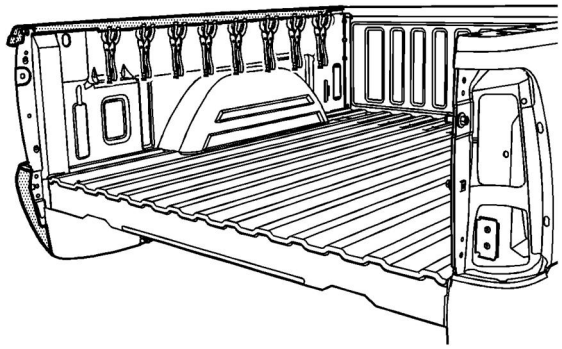


6. Apply a 9–13 mm (3/8–1/2 in) bead of metal panel bonding adhesive to the mating surface of the service side panel.



Note: Do NOT pull the panels apart after you have joined the panels together. Slide the panels against each other to realign the panels.

7. Position the service side panel to the bed assembly.



8. Clamp the service side panel into position.
9. Using lacquer thinner remove the excess adhesive from the bed side panel area.
10. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
11. Paint the repair area. Refer to Basecoat/Clearcoat Paint Systems.
12. Install all related panels and components.
13. Install the box assembly. Refer to Pickup Box Replacement.

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